

BLUE

Dart Aerospace Ltd.

Date: Monday, 05/01/2009 7:58:27 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 02.500 BLUE
Job Number : 44372	
Estimate Number : 11058	
P.O. Number :	Part Number : D28921
This Issue : 05/01/2009 S.O. No. :	Drawing Number : D2892 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 43385	Material :
Written By :	Due Date : 31/01/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLD 09.01.05</u>	
Comment : Est. C 02.11.26 Added P/O KJ Est. D 08.03.19 Re-format EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DSK077	D2892-1 TURNING DETAIL
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 3.0000 Each(s)
 D2892-1 TURNING DETAIL
 Batch: 43869

JL 09/01/07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS
 Machine as per Folio FA082
 Tumble & Deburr

JL 09/01/07

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 09/01/07

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/01/07

5.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

--PRIME grey B 110199
 --SPRAY PAINT DELFLEET BLUE B 110077
 --CLEAR DELFLEET B 110161

ET 09-01-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/01/2009 7:58:27 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.500 BLUE

Job Number: 44372

Part Number: D28921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC14

INSPECT SPRAY PAINT



ml

090113



(x6)

Comment: INSPECT SPRAY PAINT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *X base*

only

09-01-13

(x6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-1-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44372
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132	.131	.132	.132	.132
AB	0.290	0.310		.310	.310	.310	.310	.310
AC	0.040	0.060		.049	.050	.050	.051	.051
AD	0.115	0.135		.124	.123	.123	.124	.124
AE	0.240	0.260		.252	.252	.250	.249	.250
AF	0.188	0.193		.189	.189	.189	.189	.189
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	1.126	1.146		1.140	1.140	1.136	1.135	1.134
AI	0.454	0.474		.468	.467	.464	.465	.464
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.053	0.073		.063	.063	.063	.063	.063
AL	0.257	0.262		.259	.259	.259	.259	.259
AM	1.663	1.683		1.675	1.675	1.675	1.675	1.675
AN	0.053	0.073		.063	.063	.063	.063	.063
AO	0.022	0.042		.032	.032	.032	.032	.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L.
 Date: 09/01/07

Audited by: SA
 Date: 09/01/08

Prototype Approval:
 Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 44312
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	2	3	4	5
HAAS Section								
AA	0.115	0.135		.132				
AB	0.290	0.310		.310				
AC	0.040	0.060		.049				
AD	0.115	0.135		.124				
AE	0.240	0.260		.249				
AF	0.188	0.193		.189				
AG	0.240	0.260		.250				
AH	1.126	1.146		1.136				
AI	0.454	0.474		.464				
AJ	0.240	0.260		.250				
AK	0.053	0.073		.063				
AL	0.257	0.262		.259				
AM	1.663	1.683		1.675				
AN	0.053	0.073		.063				
AO	0.022	0.042		.032				
AP	2.779	2.789		2.784				
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: J.L. Date: 09/01/07

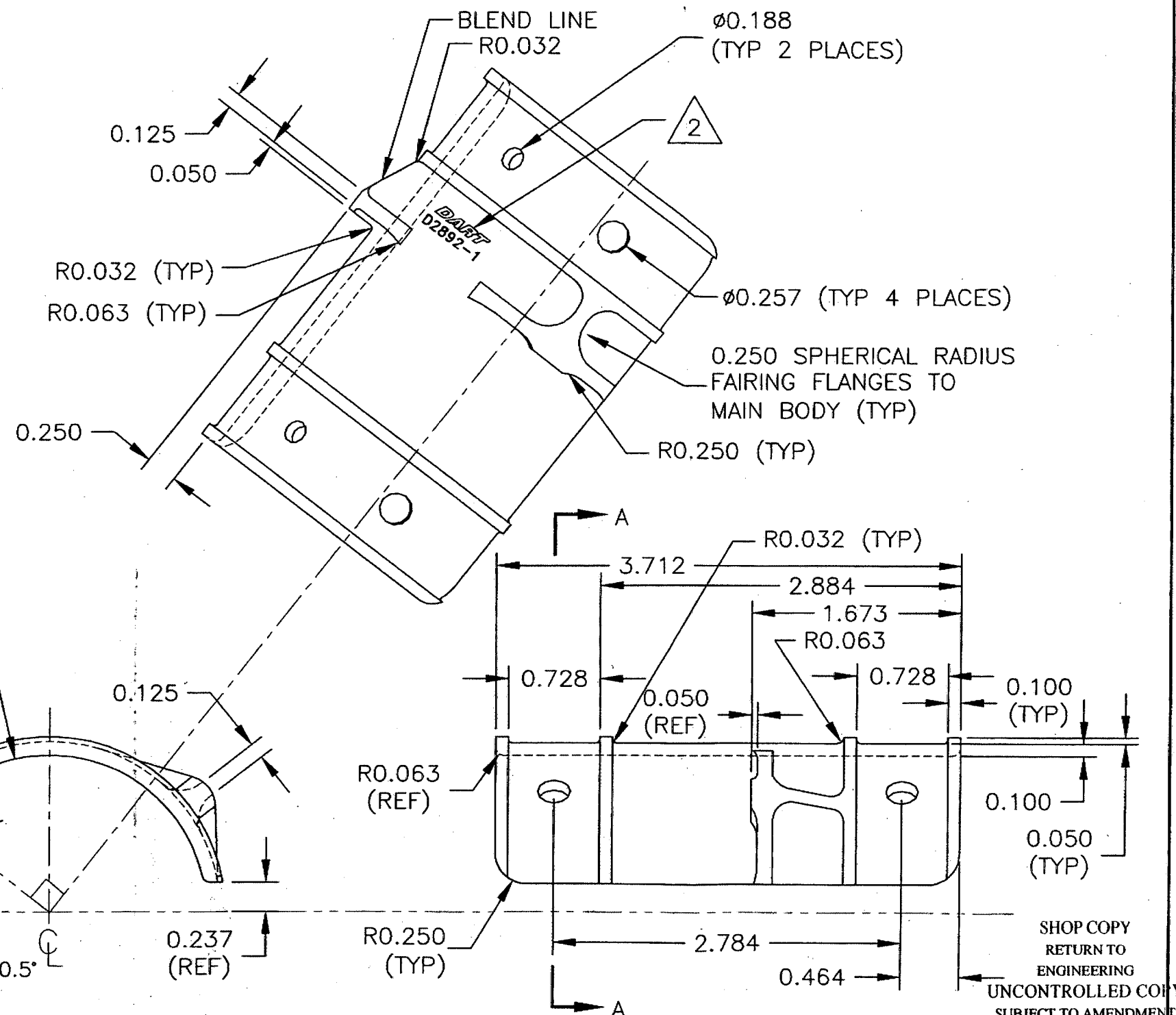
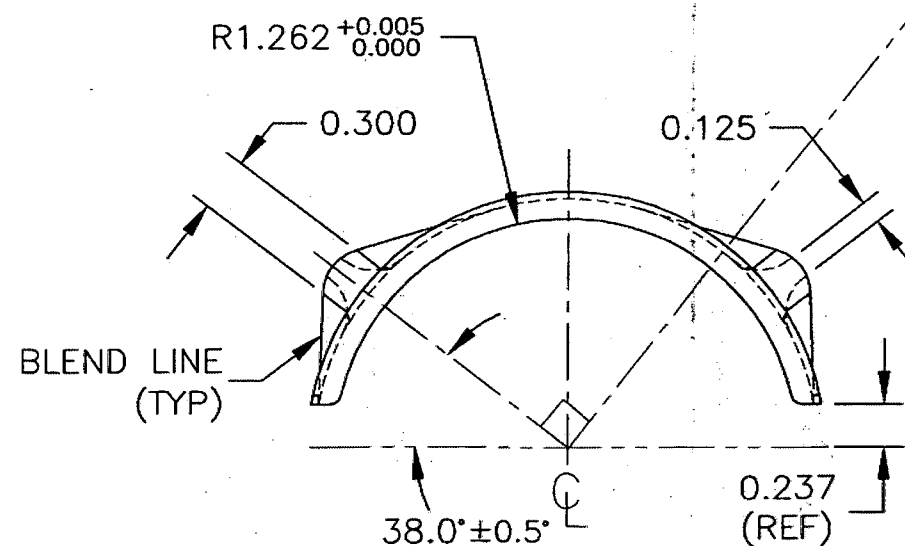
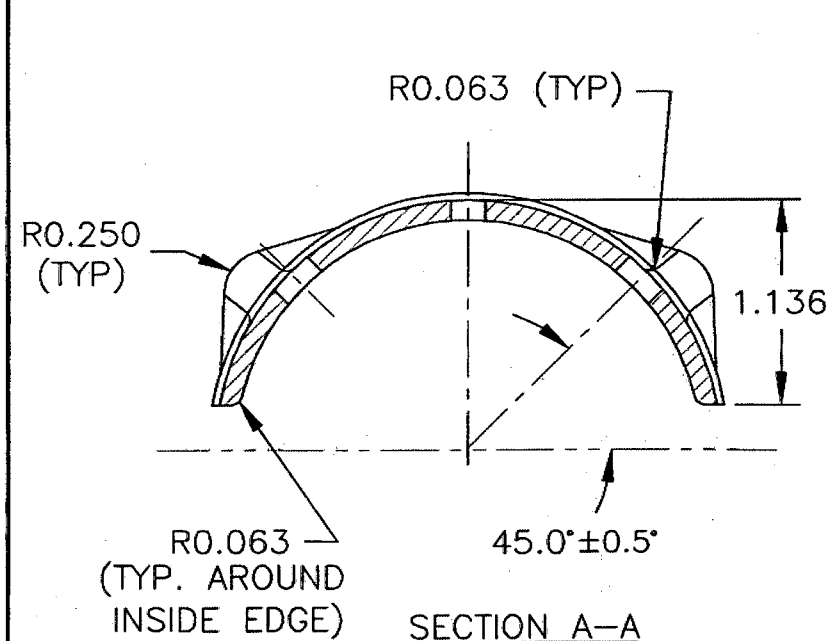
Audited by: S.D. Date: 09/01/07

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4432

A		00.11.17	NEW ISSUE
DESIGN <i>CP</i>		DRAWN BY <i>CP</i>	DART DART AEROSPACE LTD. HAMKESBURY, ONTARIO, CANADA
CHECKED <i>HH</i>		APPROVED <i>HH</i>	DRAWING NO. D2892
DATE 00.11.17		TITLE 02.500 SUPPORT	REV. A SHEET 1 OF 1 SCALE 1:1

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